

Work Order ID 70506

Friday, June 10, 2011 10:11:43 AM



Page 1

Item ID: D4403-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Rib, LH

Start Date: 6/13/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 2.00

Customer:

Reference:

Handwritten: 11-06-10

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4403	A
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100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Handwritten: 11/06/10

Handwritten: 2 0

Jeaspa Bandsaw

CUT BLANK AT 7.250"

110

0.00



HAAS 1

Memo

0.00

Handwritten: 11/06/15

Handwritten: 2 0

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FB061 & DWG
FOLIO REV: AA
DWG REV: A

DEBURR

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Page 2

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Start Date: 6/13/2011 Start Qty: 2.00



Cust Item ID:

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Customer:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC2- Inspect parts off machine FAI/FAIB

0.00

OK 11/06/15

QC

Memo

0.00

Quality Control

2 P

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 16 11/06/15

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Page 3

Item ID: D4403-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Rib, LH

Start Date: 6/13/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

2 BF 11-6-15

160



Packaging

Packaging

Identify as per dwg & Stock Location: 139F

Memo

0.00

0.00

11/6/16 J12

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

11/6/16 J12

ME

11-06-16

Picklist Print

Friday, June 10, 2011 10:11:40 AM

Page 1

Work Order ID: 70506



Parent Item: D4403-7



Parent Item Name: Vertical Rib, LH

Start Date: 6/13/2011

Required Date: 6/23/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV: A NEW ISSUE 11/06/08 JFS VERIFY BY:JLM

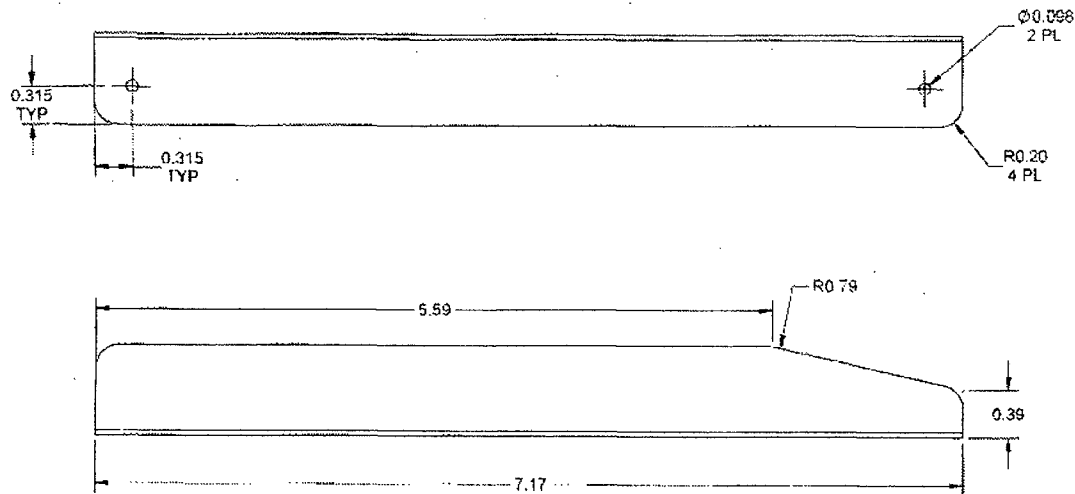
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3A0.750X0.750 X.040		Purchased	No			100	f	0.0000	0.6	1.263158			



2024-T3 ANGLE .750' X .750 X .040" WALL

M117637 x 1.26"

cmk 6/10/11



D4403-7 VERTICAL RIB, LH

NOTES:

- 1) MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE
PER QQ-A-200/3
OR AMS 4152, 4164 & 4165
REF DART SPEC M2024T3A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) SIMILAR TO AGUSTA P/N 3G2591A07451

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4403 TITLE BRACKET DATE 11.05.18	REV. A
DRAWN	RF		SHEET 7 OF 8
CHECKED	#		SCALE
MFG. APPR.	#		NTS
APPROVED	#		
DE APPR.	#		

RELEASED
2011-05-24
AND

